

Work Order ID 81053

81053

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March-07-12 2:23:31 PM

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206 (24") Bearpaw
 Start Date: 07/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 21/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/07 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

120 0.00

120

FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet Cut Blank as per D2432 File

12-03-13 (20)

130 0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio and Dwg D2432 Identify as D2432F
 3-Deburr

PD 12/03/15
 JL 12/03/16

20 ✓

140 0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

PD 12/03/15
 JL 12/03/16

20 ✓

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>only 12/03/19</i>		<u>20</u>	<u>P</u>		
151 *151* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00						<u>12/3/19</u>	<u>SP (20)</u>
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>12/3/20</u>	<u>[Signature]</u>

12-03-20

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Picklist Print

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Work Order ID: 81053

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Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

573.6043

3.7

74

**

W 12.03.12

MUHMWB10

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

316.48

120035

74.48

120401

242

MAT019

257.1243158

117321

74.6

117738

93.28

117819

83.3

118814

1.5

119145

4.44431579

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	81053
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		VERN	GA-09
B	5.500	+/-0.030	5.500	✓		"	"
C	0.200	+/-0.030	0.200	✓			GA-08
D	0.25 x 45°	+/-0.030	0.250 x 45°	✓		VERN	GA-09
E	R0.250	+/-0.030	0.250	✓		RADIUS G.	
F	0.250	+/-0.010	0.244	✓		MIC	118120
G	0.625	+/-0.030	0.624	✓		VERN	GA-09
H	0.375	+/-0.010	0.380	✓		MIC	118120
I	0.950	+0.030/0.010	0.958	✓		VERN	GA-09
J	19.000	+/-0.030	19.000	✓		M-TAPE	
K	3.14	+/-0.030	3.140	✓		VERN	GA-09
L	3.28	+/-0.030	3.280	✓		VERN	GA-09
M	Ø0.260	+0.005/-0.000	0.260	✓		PIN G.	
N	Ø0.93	+/-0.030	0.925	✓		VERN	GA-09
O	0.30	+0.030/-0.000	0.300	✓			GA-08
P	23.750	+/-0.030	23.750	✓		M-TAPE	
Q	7.375	+/-0.030	7.385	✓		H-G.	
R	4.250	+/-0.010	4.253	✓		VERN	GA-09
S	2.000	+/-0.030	2.005	✓		VERN	GA-09
T	9.000	+/-0.010	9.000	✓		h-G	
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	0.375	✓		VERN	GA-09

Measured by:	PO/SL	Audited by:	SL	Prototype Approval:	N/A
Date:	12/03/15	Date:	12/03/17	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	TF

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F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
98.06.17 KE

DART

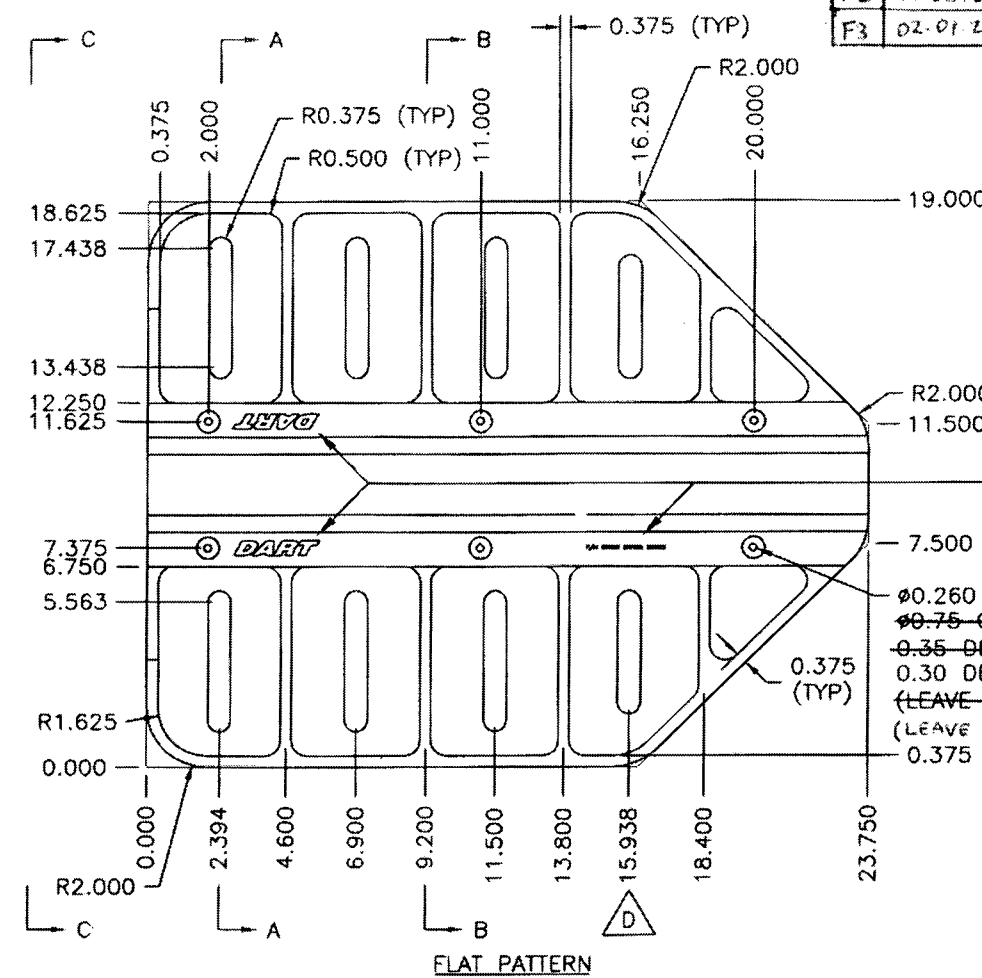


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM	JS	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

NO. 81053 MCT 12/03/07

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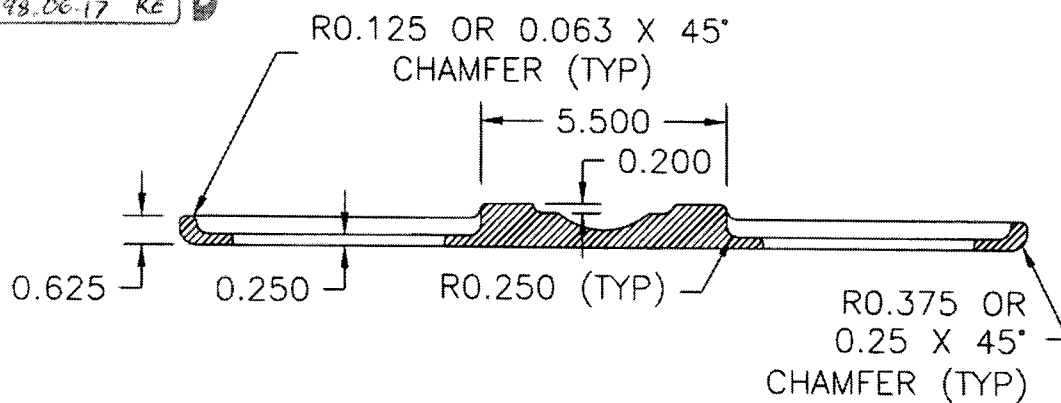
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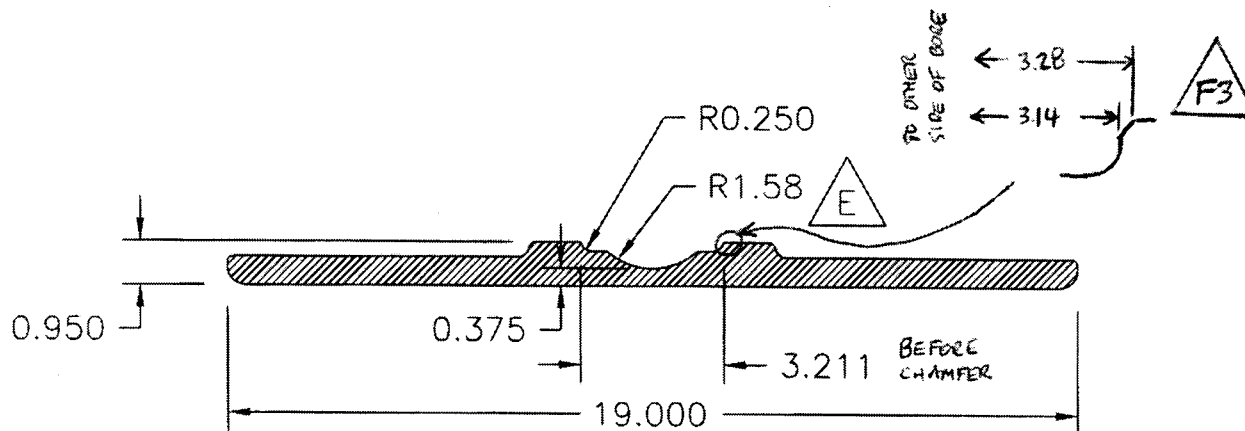


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

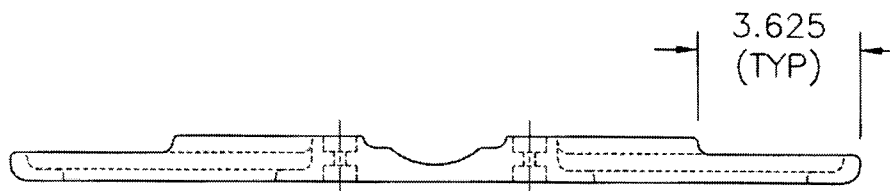
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

81053

Dart Aerospace Ltd

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